

Work Order ID 70459-2

Wednesday, June 08, 2011 7:44:44 PM

Page 1

Item ID: D2574

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, Aft In 205

Start Date: 6/16/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2574

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 70459 Double check by: H.A. ☐ 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ☐ 3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/27

10

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2573 & D2574

SL 11/06/27

10

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/06/27

10

0

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Accept

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Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10. 6 24 10 06 130

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

10/6/30 (12)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/30

11/06/30

Picklist Print

Wednesday, June 08, 2011 7:44:40 PM

Page 1

Work Order ID: 70459



Parent Item: D2574



Parent Item Name: Saddle, Aft In 205

Start Date: 6/16/2011

Required Date: 6/24/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev: 1 As Per RevE 06-01-27 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-005		Manufactured	No			110	Each	63.0000	1	12			
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Saddle Billet



110667

Location

Loc Qty

Loc Code

MAT045

27

66966

27

MAT046

36

65382

11

65953

16

66966

9

12

DART AEROSPACE LTD	Work Order:	70459
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.001		
F	0.490	0.510		.499	.500	.502	.501		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.501	.501	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.569	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.126	.127	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.240	.240	.239	.241		
W	0.115	0.135		.123	.121	.123	.123		
X	0.307	0.312		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.249	.249		
AE	1.500	1.520		1.513	1.513	1.513	1.511		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.250	.251		
AI	2.000	2.020		2.003	2.003	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	11/06/21

Audited by:	B.A
Date:	11/06/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	<i>70459</i>
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.000	8.001	8.001		
F	0.490	0.510		.501	.501	.500	.500		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.126	.125	.127	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.240	.240	.241		
W	0.115	0.135		.123	.122	.123	.123		
X	0.307	0.312		.310	.310	.310	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.249	.250		
AE	1.500	1.520		1.510	1.512	1.512	1.512		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.251	.250	.250	.250		
AI	2.000	2.020		2.000	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>ST</i>
Date:	<i>11/06/22</i>

Audited by:	<i>B.A</i>
Date:	<i>11/06/22</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	70459
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	211	212		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.501	.501	.503		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.501	.501	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.568	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.128	.128	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.123	.123	.123	.124		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.363	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.248	.250	.249		
AE	1.500	1.520		1.511	1.512	1.512	1.512		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.248	.240	.240	.240		
AH	0.240	0.260		.250	.251	.250	.251		
AI	2.000	2.020		2.001	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

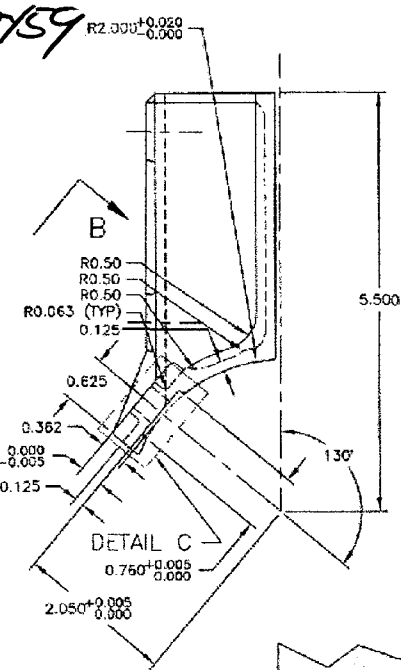
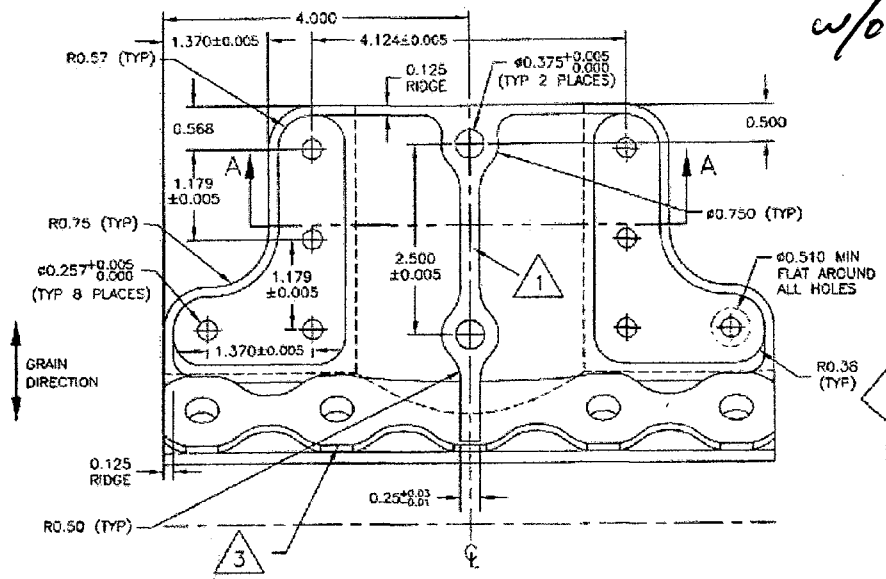
Measured by:	<i>[Signature]</i>
Date:	11/06/23

Audited by:	<i>R.A.</i>
Date:	11/06/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

w/0 70/59

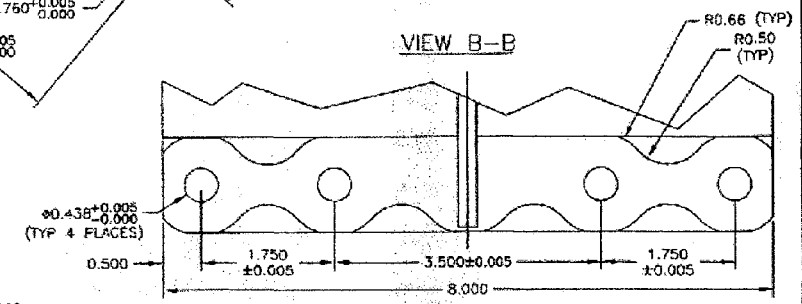
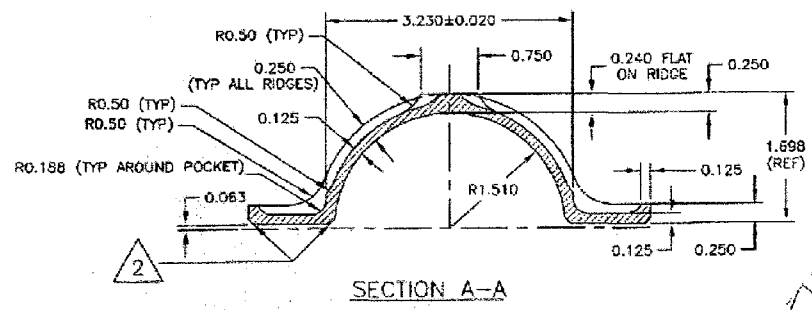
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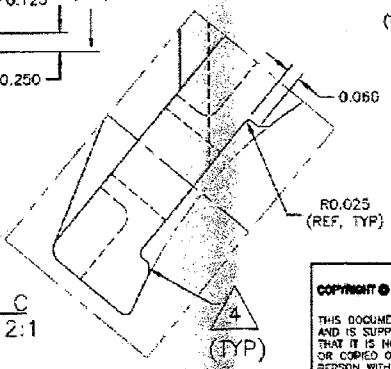
NOTES

MATERIAL: 7075-T7351 (00-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)



DETAIL C
SCALE 2:1



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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	✓	APPROVED
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

DART DART AEROSPACE LTD.
HAMPSHIRE, ENGLAND, CANADA